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D5159-1

Job Sheet 198633



Part No: D5159-1

Job Qty: 10 pcs

Part Name: Rib



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/19

Job Tracking No:

Due Date: 8/19/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 14.10.03 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	HAAS 4 Axis	10 pcs	8/19/19		1.00	2.50	HAAS - 1		mm L 19/9/03
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
130	QC 2	10 pcs	8/19/19		0.00	0.00	QC 2 - 1		mm L 19/9/03
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

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Container No: S211035



Part: D5159-1

Job No: 198633

Serial No/Batch: S211035

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/03/19

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					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	10	8/19/19	0.00 0.00	QC 8 - 12	DAS 14 9-89
	pcs				QC 8 - 14	19/09/11
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
150	Powdercoat - 3 Grey Sand - B4B	10	8/19/19	0.00 0.20	Powdercoat - 1 - B4B	
	pcs				Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BK 19-10-13.
					Powdercoat - 4 - B4B	
160	QC 3	10	8/19/19	0.00 0.00	QC 3 - 10	
	pcs				QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	DAS 40 9-89
					QC 3 - 19	SEP 13 2019
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	

170	Packaging 3-1 - Stock - B4B	10 pcs	8/19/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC ST 350
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS 21
180	QC 21 - SA	10	8/19/19	0.00 0.00	QC 21 - SA - 21	SEP 1 7 2019
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pcs

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 120 - (Manufacture as per dwg) DRILL HOLES AND MILL ENDS AS PER DWG ***ENSURE MATERIAL SEAM IS AT
 Descriptions: THE BOTTOM OF THE PART WHERE THERE IS NO HOLES***

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TS0.750W.049	304 Sq Tube .75X.75X.049W	12.2700 ft (1.227 ea)	120-HAAS 4 Axis	5201998

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-HAAS 4 Axis	M304TS0.750W.049	12	568	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Rib	14.700Inches ± 0.030	14.730 14.670		14.699
2	Rib	12.790Inches ± 0.030	12.820 12.760		12.790
3	Rib	0.950Inches ± 0.010	0.960 0.940		.954
4	Rib	0.266Inches ± 0.010	0.276 0.256		.266
5	Rib	0.297Inches ± 0.010	0.307 0.287		.297
6	Rib	0.400Inches ± 0.030	0.430 0.370		.400
7	Rib	1.000Inches ± 0.010	1.010 0.990		1.001
8	Rib	3.000Inches ± 0.010	3.010 2.990		3.000
9	Rib	2.000Inches ± 0.010	2.010 1.990		2.000
10	Rib	2.000Inches ± 0.010	2.010 1.990		2.000
11	Rib	3.000Inches ± 0.010	3.010 2.990		3.000
12	Rib	1.000Inches ± 0.010	1.010 0.990		1.000
13	Rib	0.129Inches + 0.005 - 0.001	0.134 0.128		.129
14	Rib	2.440Inches ± 0.030	2.470 2.410		2.440
15	Rib	2.625Inches ± 0.010	2.635 2.615		2.628
16	Rib	0.129Inches + 0.005 - 0.001	0.134 0.128		.125
17	Rib	0.350Inches ± 0.030	0.380 0.320	Radius	.350

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				MRB (QSI042)	
Date : _____		Sequence #: _____		QTY Affected : _____		Disposition			
Description Work Order Deviation									
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				Completed By Lead hand / Supervisor QC / QA Coordinator					